

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016882**Date Inspected:** 26-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>			
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Orthotropic Box Girder( OBG)				

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

Segment # 11DE

This QA performed Visual Testing (VT) and dimensional inspection on cope and weld access holes inside Orthotropic Box Girder (OBG) lift 11DE. Smoothness & Size of cope .American Bridge Fluor (ABF) QA inspectors have previously inspected and accepted these cope holes and recorded their findings on ABF document CWAHIR-11DE-01 dated 25th Aug 2010.

Segment # 11DE (Green Tag)

This QA performed a joint survey dimensional inspection of Plumbness & Flatness on segment 11DE. The inspection was performed along with Caltrans (CT) QA Mr.Shailesh Wadkar. Measurements of the Deck Panel diaphragm plate plumbness & Flatness were taken from PP104 to PP106. Details of these locations can be found

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on CT / QA document titled “OBG DCP Hand Measurement Survey: Deck Panel Diaphragm Plate Plumbness & Flatness”. This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

This QA performed a joint survey dimensional inspection of Flatness on segment 11DE. The inspection was performed along with Caltrans (CT) QA Mr. Shailesh Wadkar. Measurements of the Floor Beam Flatness were taken from PP104 to PP106 (Cross Beam & Bike Path Side). Details of these locations can be found on CT / QA document titled “OBG DCP Hand Measurement Survey: FB Flatness”. This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

This QA performed a joint survey dimensional inspection of corner assembly cope holes on segment 11DE. The inspection was performed along with Caltrans (CT) QA Mr. Shailesh Wadkar. Measurements of the cope holes were taken from PP104 to PP106.5 at the following locations: E1~E2, S1~S5 and T1~T3 on both the crossbeam and bike path sides. Details of these locations can be found on CT / QA document titled “OBG DCP Hand Measurement Survey: Corner Assembly Cope Holes”. This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

This QA performed a joint survey dimensional inspection of corner assembly Side Panel to Corner Assembly Longitudinal Weld Flatness & Deck Panel to Corner Assembly on segment 11DE. The inspection was performed along with Caltrans (CT) QA Mr. Shailesh Wadkar; Measurements of the Flatness were taken from PP104 to PP106.5. Details of these locations can be found on CT / QA document titled “OBG DCP Hand Measurement Survey: Corner Assembly SP-SP & DP-DP Flatness”. This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhune, Manoj	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson, Rodney	QA Reviewer

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